

Work Order ID 57224

March 30, 2010 10:44:50 AM



Page 1

Item ID: D3573-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 08/04/2010 Req'd Qty: 10.00

Customer:

Reference: *10-03-30*

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3573

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.500" long

SP 10/03/31

10 *Ø*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA677 and Dwg D3573

SP 10/03/31

10 *Ø*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SP 10/03/31

10 *Ø*



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Item ID: D3573-7

Accept

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Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

JL 10/04/05

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

JL 10/04/06

Memo

0.00

(X10) Ø

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11112588

Memo

0.00

=> JL 10/04/07

X10 Ø

START TIME:

3:15pm

OVEN TEMPERATURE:

3:45pm FINISH TIME:

320°F

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Item ID: D3573-7

Accept

Revision ID:

Item Name: Adapter

Start Date: 30/03/2010 Start Qty: 10.00

Required Date: 08/04/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

*bl 10-4-8**(10) 0*

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location:

244

0.00

Memo

0.00

10/4/9 (10)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/12
MF 10-4-10

Picklist Print

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Page 1

Work Order ID: 57224

Parent Item: D3573-7

Parent Item Name: Adapter

Comments: IPP Rev:A New Issue 07-01-29 JLM

Start Date: 30/03/2010

Required Date: 08/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	27.5923	3.0737			



6061-T6 Bar .500 x 2.50



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT02	27.59231579	
103435	1.06	
104366	26.5323158	

3.0737 S.F. 10/03/31
+ 3" scrap mat.

DART AEROSPACE LTD		Work Order:	
Description: Adapter		Part Number:	D3573-8
Inspection Dwg: D3573	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.313	✓			
2.75	+/-0.030	2.750	✓			
0.36	+/-0.030	.354	✓			
1.600	+/-0.010	1.601	✓			
0.48	+/-0.030	.473	✓			
2.38	+/-0.030	2.372	✓			
1.420	+/-0.010	1.419	✓			
1.813	+/-0.010	1.813	✓			
Ø0.209	+0.005/-0.001	.211	✓			
Ø0.201	+0.005/-0.001	.202	✓			
Ø0.90 x 0.100	+/-0.010	.897	✓			
Ø0.500 x 0.310	+/-0.010	.496 x .313	✓			
0.390	+/-0.010	.382	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380	✓			
R0.63	+/-0.030	.63	✓			
R0.13	+/-0.030	.13	✓			
R0.02	+/-0.030	0.0	✓			

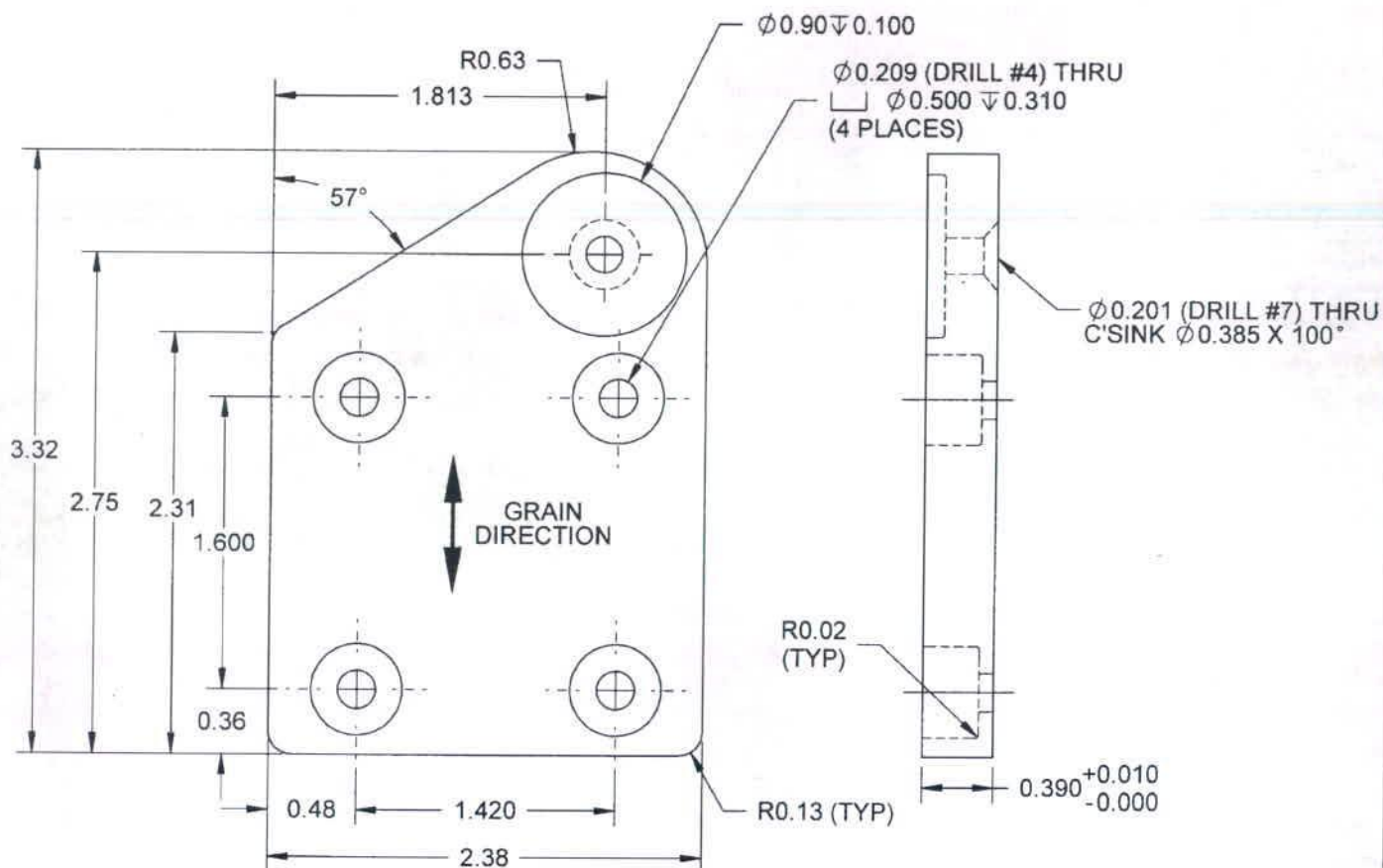
Measured by: <u>Q.S</u>	Audited by: <u>SL</u>	Prototype Approval:	N/A
Date: <u>10/03/31</u>	Date: <u>10/04/05</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573
DATE 07.02.19	TITLE ADAPTER	REV. A SHEET 4 OF 4 SCALE 1:1

RELEASED
07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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